

ASAP

Dart Aerospace Ltd.

Date: Thursday, 3/27/2008 7:41:55 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HINGE HALF
Job Number : 38225	
Estimate Number : 13142	
P.O. Number :	Part Number : D37481
This Issue : 3/27/2008 S.O. No. :	Drawing Number : D3748 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 37305	Material :
Written By :	Due Date : 4/2/2008 Qty: 8 Um: Each
Checked & Approved By : <u>JD 08-03-27</u>	
Comment : Est Rev:A 08-01-30 new issue DD verified by:EC	
Est Rev:B 08-02-27 rev.A as per ecn 1139 DD verified by:	

## Additional Product

Job Number: -



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S11GA	304/316 .125 Sheet
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Comment: Qty.: 0.0358 sf(s)/Unit Total : 0.2864 sf(s)

304/316 stainless steel sheet .125" thick

(M304S11GA)

Batch: 104934 IB 8-3-28

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3748

Dwg Rev: AProg Rev: A

2- Deburr if necessary

IB 8-3-28

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-3-28

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1- Deburr if necessary

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/27/2008 7:41:55 AM

User: Kim Johnston

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Drawing Name: HINGE HALF

Job Number: 38225

Part Number: D37481

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



5 08/03/31 (K9)

Comment: INSPECT WORK TO CURRENT STEP

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3748

SR 08/03/31

(9)

8.0

QC5

INSPECT WORK TO CURRENT STEP



5 08/03/31 (K9)

Comment: INSPECT WORK TO CURRENT STEP

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS7

2 3 08-04-01

(X9)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/03  
9/1

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-03-31

W

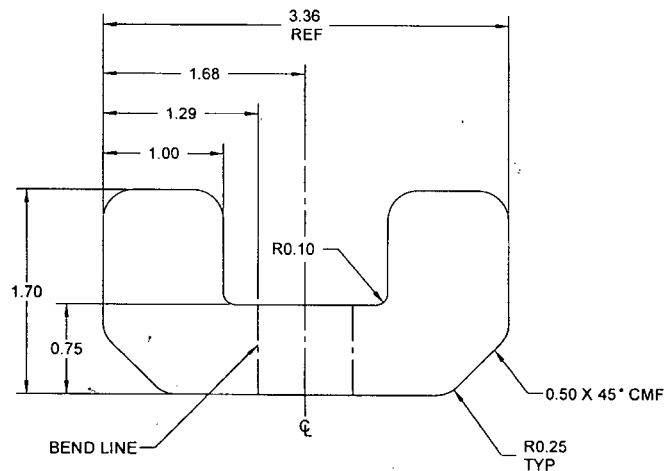
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

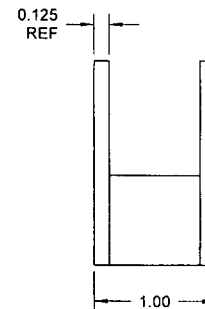
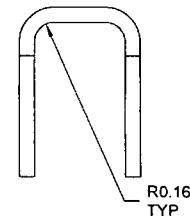
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3748-1F FLAT PATTERN**



**D3748-1 HINGE HALF**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.125 THICK  
PER MIL-S-5019 (ANNEALED) 2B FINISH  
(REF. DART SPEC M304S11GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.15 lbs

NO. 38225  
WORK ORDER  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

A		INITIAL RELEASE		AJS	08.02.05
REV.		DESCRIPTION		BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3748</b> TITLE <b>HINGE HALF</b>			REV. A
DRAWN	AJS				SHEET 1 OF 1
CHECKED	KE				SCALE
MFG. APPR.	MD				1:1
APPROVED	MD				
DE APPR.	MD				
DATE	08.02.05				

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